

CLAIMS

1. A method of manufacturing a pneumatic tire comprising a tread portion, a pair of sidewall portions and a pair of bead portions communicating with both sides of the tread portion, and a bead guard disposed in at least one bead portion and protruding outward from the tire by vulcanization-shaping with a split type mold comprising a pair of annular side rings forming the pair of bead portions and the pair of sidewall portions and many split segments for the formation of the tread portion integrally united and engaged with the respective side ring, characterized in that an edge of a dividing face between mutually adjoining side ring pieces by annularly dividing the side ring inward and outward in a radial direction with respect to a center axis line of the split type mold and located at a side of a tire shaping face is positioned in a place corresponding to a depressing portion forming a bead guard.

2. The method according to claim 1, wherein the edge of the dividing face between the adjoining side ring pieces located at the side of the tire shaping face is positioned in a place corresponding to a bottom of the depressing portion.

3. The method according to claim 1 or 2, wherein the edge of the dividing face between the adjoining side ring pieces located at the side of the tire shaping face is positioned in a place corresponding to a corner part of the depressing portion forming the bead guard.

4. The method according to any one of claims 1 to 3, wherein the edge of the dividing face between the adjoining side ring pieces located at the side of the tire shaping face is positioned in a place corresponding to a deeper corner part among plural corner parts of the depressing portion forming the bead guard.

5. The method according to any one of claims 1 to 4, wherein the edge of the dividing face between the adjoining side ring pieces located at the side of the tire shaping face is positioned in a place corresponding to an outward corner part in the radial direction at a side delaying the enlarging deformation of the uncured tire among corner parts adjoining to each other inward and outward in the radial direction in the depressing portion forming the bead guard.

6. A vulcanization split type mold comprising a pair of annular side rings forming a pair of bead portions and a pair of sidewall portions of a pneumatic tire, many split segments for the formation of a tread portion of the

7. A vulcanization split type mold according to claim 6, wherein the edge of the dividing face between the adjoining side ring pieces disposed in the depressing portion and located at the side of the tire shaping face is positioned in a bottom of the depressing portion.

9. A vulcanization split type mold according to any one of claims 6 to 8, wherein the edge of the dividing face between the adjoining side ring pieces forming the depressing portion and located at the side of the tire shaping face is positioned in a deepest bottom corner part among plural bottom corner parts of the depressing portion.

11. A vulcanization split type mold according to any one of claims 6 to 10, wherein each of the side rings is divided into three or more side ring pieces.

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wherein a chamfered portion specifying a position of the edge of the dividing face located at the side of the tire shaping face is formed in at least one of the mutually adjoining side ring pieces.

13. A vulcanization split type mold according to any one of claims 6 to 12, wherein the side ring pieces in each of the side rings have a structure capable of assembling and disassembling them and are integrally united with each other in a vulcanization work inclusive of opening and closing of a vulcanizing machine provided with the mold.